

Work Order ID 53061

October 22, 2009 1:59:37 PM



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Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

PP

Date:

09-10-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 003

5/10/04/20

HJ Rec BG 10/04/13

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

RT 10-03-23

120

0.00



Small Fab

Memo

0.00

Small Fab

-Assemble as per dwg D3188,
-use door to transfer drill hole location.
-Install inserts

RT 10-03-24

(A10)

W/O: 53061		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-03-23	110	B missing D 2179 in ^{rate} seq 110 Back plate D 2179 B 35432 x 2 ^{perm change}	BT	10-03-23			S 10/6/14	
10-03-24	110	missing screw MS-27039-08-11 x 2 m. 11.1977 nylon washer NAS1515 H3 x 2 m. 11.1268 nut MS21042608 x 2 M 113749 washer AN960508 NAS1149DN8321 x 1 M 114108 ^{perm change}	BT	10-03-24			S 10/6/14	


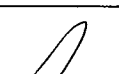


Part No: D130-780-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O: 53061		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-03-24	120	remove foam core as per IIN-D350-600 Figure 17a. Fill hole w/Hysol 934NA w/10% milled fibre Hysol <u>B 113022</u> exp <u>10-09-18</u> milled fibres <u>B 100859</u>	BT	10-03-24		 10-3-24	 10-3-24	
10-03-24		prime as per QSR 005 <u>QC 14 8/10/05</u> install hardware to spacepad ensure proper fit	BT BT	10-03-24 10-03-24 10-03-24	 ① 	 10-3-24	 10-3-24	

Part No: D130-780-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00



8/06/05

QC

Memo

0.00

Quality Control

⑦

140

Wing Walk as per dwg QSI005 4.4 Batch 113462 0.00



HandFinish

Memo

0.00

Hand Finishing

TOP SURFACE OF POD

ZT 10-04-05

150

QC3- Inspect Part Finish

0.00



8/10/04/20

QC

Memo

0.00

Quality Control

⑦

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Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-4-14 *sl* *Pho*

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*8/10/12**(X)*

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-042

Location: _____

PPP Rev: *C**10/8/12 sl*

Dart Aerospace Ltd

W/O: 53061		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/01/14	#160	Perm. Change wrong Qty For NAS1149D0363 should be x14 per kit M114292/1000 wrong Qty For MS21042L3 should be x22 per kit update w/o + Bom.	PC	10/4/14			S 10/01/14	
	#160	missing Bom w/o MS21059L3 M 113292 +10 per kit S.10/04/14 update w/o + Bom. add copy of Bom's for Ref.	PC	10/4/14			S 10/01/14	

Part No: D130-780-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53061

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Item ID: D130-780-042

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Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____


Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

MF
10-8-12

Picklist Print

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D130-780-044RevA		Manufactured	No			110	Each	0.0000	1.0000			
												
53071											RT	10-04-01
Spacepod Door Assembly, RH												
D3188-2MRevE		Manufactured	No			110	Each	1.0000	1.0000			
												
53076											RT	10-04-01
SPACEPOD BODY RH												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

CA

1

46180A

1

AKS4-1032-130

Purchased

No

110

Each

1.0000

28.0000



Inserts

AKS4-1032-130

as per QSR 17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

6087

1

D3837-4RevB

Manufactured

No



Decal

166 110

Each

5.0000

1.0000

KAN 10/18/12 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

46233

5

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237RevD1 Striker Plate		Manufactured	No			110	Each	81.0000	2.0000			

25 10.03.23

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	5	
46162	5	
Main Warehouse		
ST022	76	
50348	21	
52327	55	

355006 x2

MS20426AD4-5

Purchased

No

110

Each

7,910.000 4.0000



Rivet

25 10.03.23

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	7910	
4067	1097	
6733	1831	
6874	4982	

M6733 x4

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3538-1RevA  Hinge Bracket		Manufactured	No			110	Each	24.0000	2.0000			

RT 10-03-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

14

48197

14

Main Warehouse

ST111

10

50336

10

x2

AN526-832R24

Purchased

No



Screw

AN526-832R24

110

Each

201.0000

4.0000

RT 10-03-23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

16895

201

M 110179 x4

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1149DN832J
WASHER

No

110

Each

375.0000

4.0000

~~114108~~ 8T 10-03-23

Warehouse

Loc Qty

Loc Code

M114108

Location

Main Warehouse

ST

375

111193

3

111359

72

112385

300

MS21042L08

Purchased

No

110

Each

407.0000

4.0000

8T 10-03-23

Nut

Warehouse

Loc Qty

Loc Code

M113749x4

Location

Main Warehouse

ST

407

110002

24

111889

51

112243

47

112492

85

112612

100

112794

100

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3815-041RevA

Manufactured

No

160

Each

7.0000

2.0000

Web Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

45729

1

46356

6

160

Each

7.0000

1.0000

D3837-1RevB

Manufactured

No

Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

46231

7

160

Each

2.0000

1.0000

D3798-042RevA

Manufactured

No

Spacepod Floor

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

50351

2

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3547-1RevA

Manufactured

No

160

Each

22.0000

1.0000

10-4-14 SP



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

35455

8

50260

14

D3550-1RevB

Manufactured

No

160

Each

17.0000

1.0000

10-4-14 SP



Strut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

48367

17

D3554-7RevA

Manufactured

No

160

Each

60.0000

1.0000

10-4-14 SP



Ball Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

37674

60

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Work Order ID: 53061



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3RevB  Locknut		Manufactured	No			160	Each	328.0000	1.0000			

10-4-14 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	128	
43758	26	
44446	49	
48238	53	

Main Warehouse

ST59	200	
51711	200	

AN3-3A

Purchased

No

160

Each

161.0000

4.0000

Bolt



1113121 SP 10-4-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	161	
111925	11	
112314	50	
112720	100	

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-6A  Bolt		Purchased	No			160	Each	135.0000	4.0000	2	11/3/08	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	135	
112082	7	
112513	28	
112720	100	


AN3-10A  Bolt		Purchased	No			160	Each	73.0000	2.0000		10-4-14 SP	
--	--	-----------	----	--	--	-----	------	---------	--------	--	------------	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	73	
111119	73	

AN5-5A  Bolt		Purchased	No			160	Each	107.0000	1.0000	2	10-4-14 SP	
---	--	-----------	----	--	--	-----	------	----------	--------	---	------------	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	107	
103585	3	
110363	4	
110865	100	

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Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R7  Screw		Purchased	No			160	Each	131.0000	38.0000			

M113208 10-4-14 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	131	
106166	30	
110844	15	
112314	10	
112411	76	

MS24694-S67



Screw

Purchased No

160 Each 103.0000 7.0000

10-4-14 SP 10-4-14 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	103	
101662	13	
106166	1	
111965	89	

7

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R14		Purchased	No			160	Each	937.0000	8.0000			
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

937

104916

937

MS24694-S69

Purchased

No

160

Each

118.0000

1.0000

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

118

103574

5

110153

13

112492

100

A3235-020-935

Purchased

No

160

Each

694.0000

8.0000

Washer - Countersunk

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

694

104156

3

106150

691

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Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0363J		Purchased	No			160	Each	2.0000	8.0000 19.00	76	10/4/13	
										M114292	10-4-14	SP
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

112314

2

NAS1149D0332J

Purchased

No

160

Each

342.0000

16.0000



Washer

M113237 10-4-14 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

342

110625

16

110844

126

112794

200

NAS1149D0563J

Purchased

No

160

Each

100.0000

3.0000



Washer

M113706 10-4-14 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

100

112794

100

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Required Date: 04/11/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No			160	Each	3,430.000	16.0000		2.16 10/14/13 M113537 10-4-14	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3430	
110844	32	
111274	35	
111668	863	
112314	2000	
112385	500	

MS21042L5



Nut

Purchased

No

160

Each

1,077.000

1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1077	
110382	10	
111127	4	
111636	63	
112314	1000	

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Work Order ID: 53061

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AKS4-1032-130 Purchased No

160

Each

1.0000

10.0000



Inserts AL571032-130

651 g/f



1113288 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

6087

1

D130-780-013RevA

Manufactured

No

160

Each

2.0000

1.0000



Switch Relocation

CH47001



10414 SP 10-4-14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

50272

2

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GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

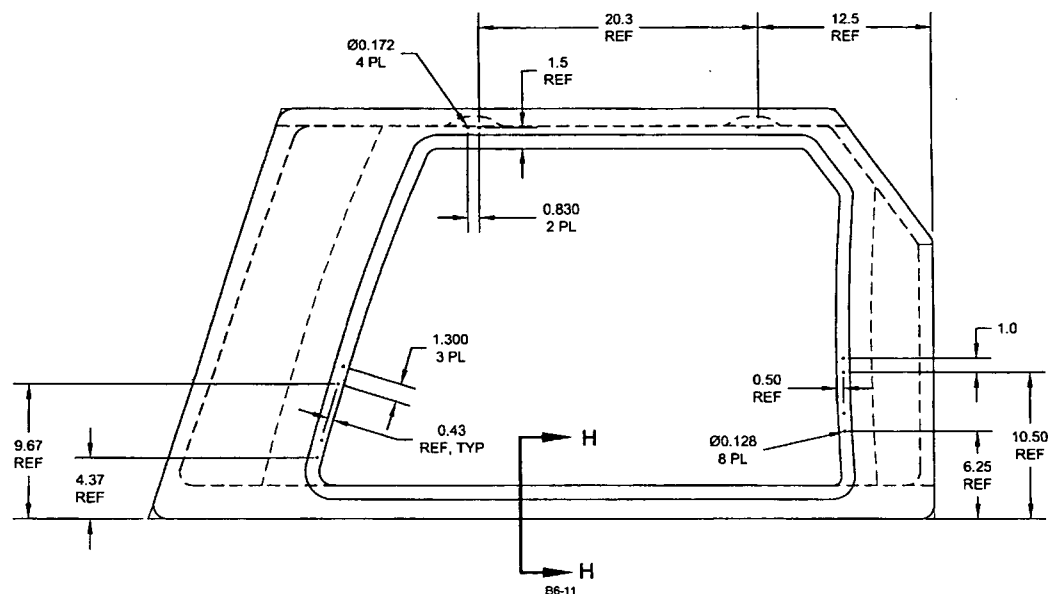
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITHOUT NOTICE
WORK ORDER
NO. 53061
BPO-10-22

RELEASED
2009-10-20
MD

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0800-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

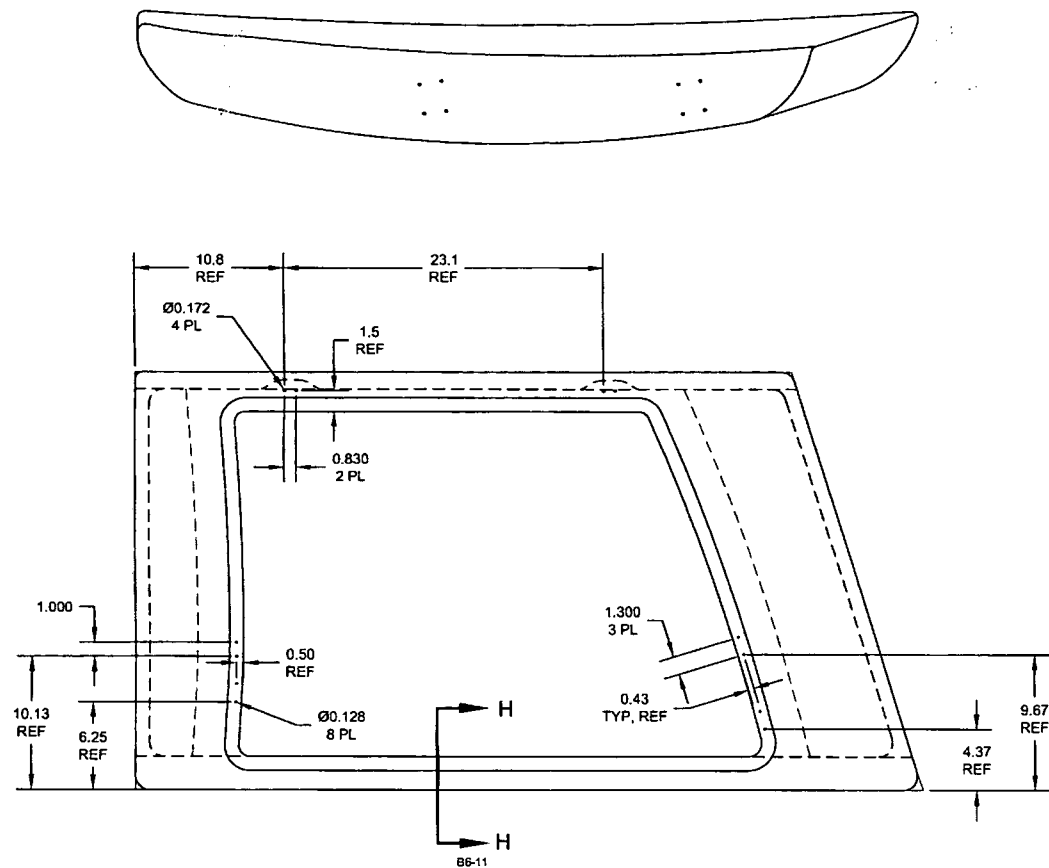
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
MP

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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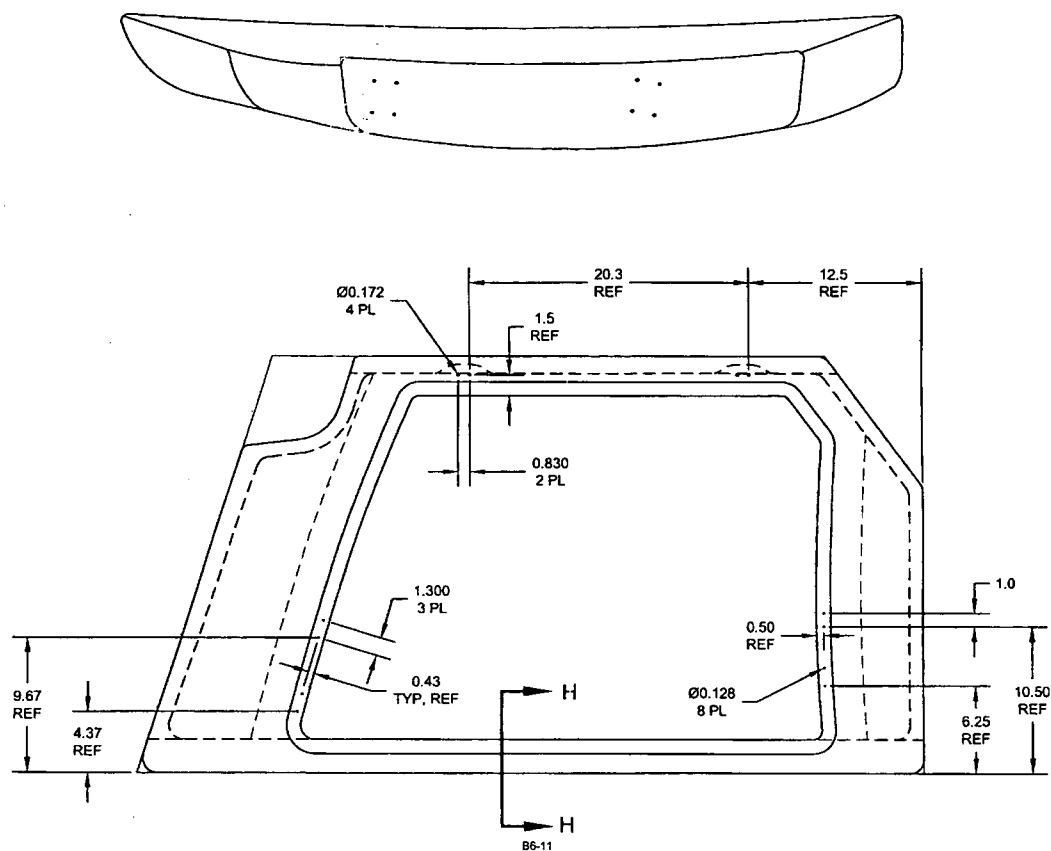
D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
MP

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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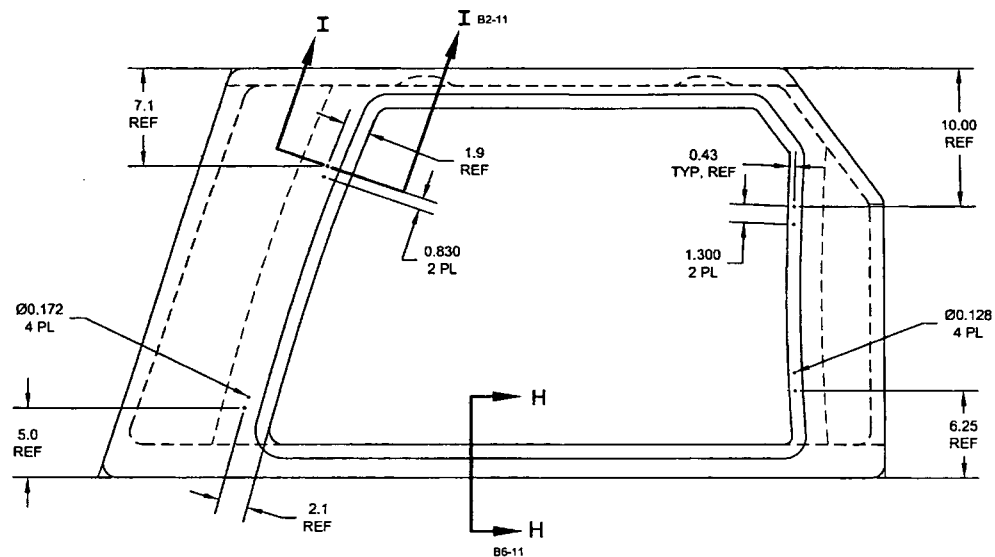
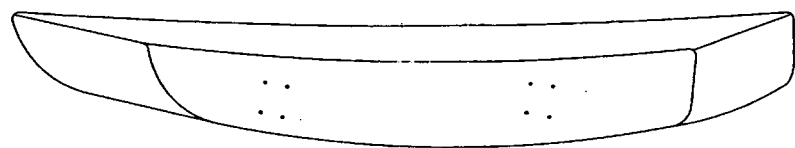
D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

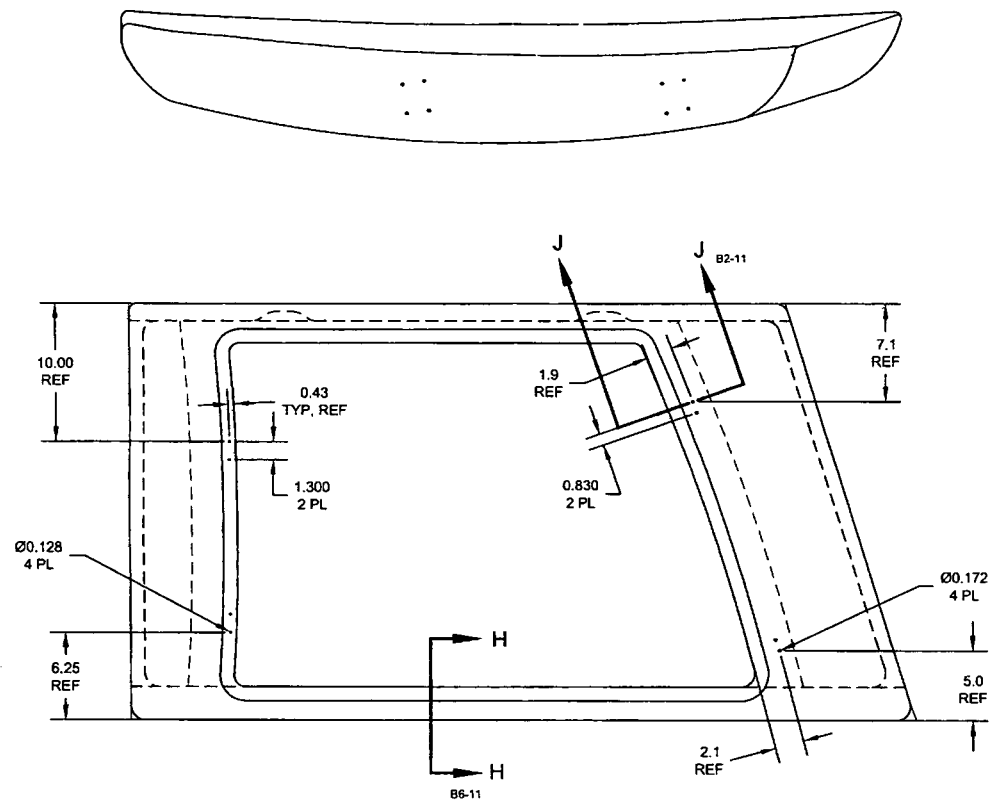
RELEASED
2009-10-20
MD

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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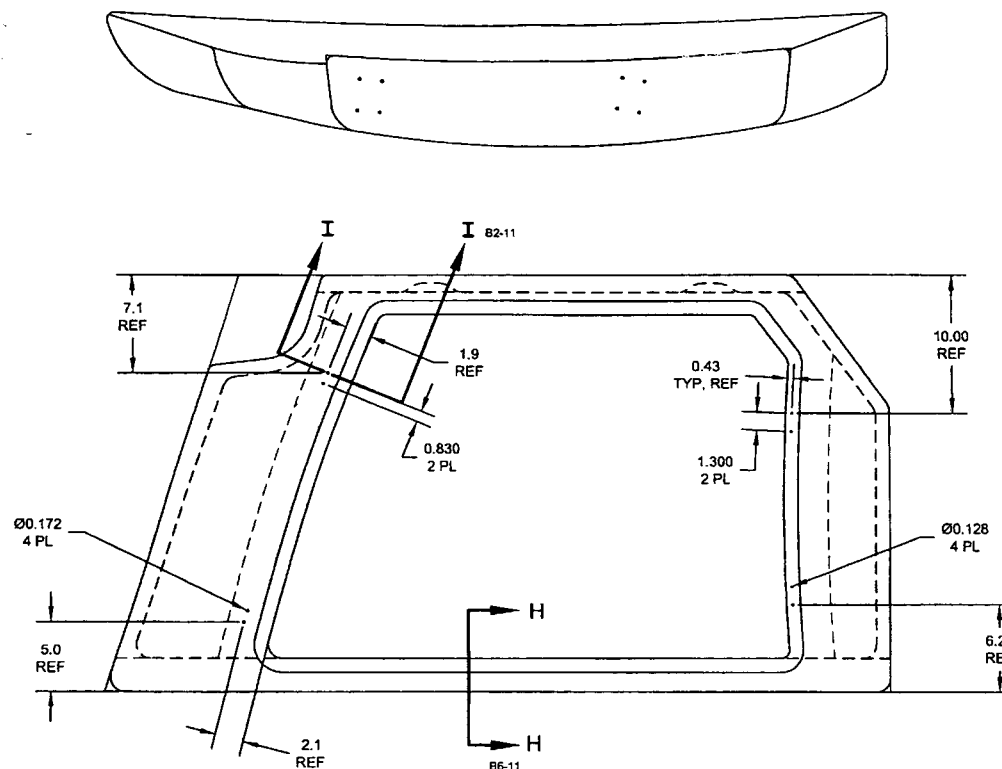
D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

RELEASED
2009-10-20

- NOTES:**
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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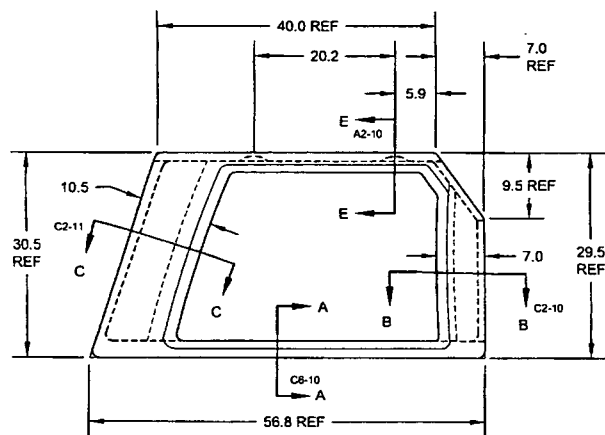
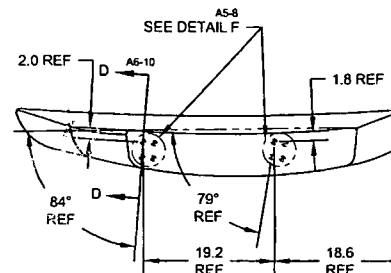
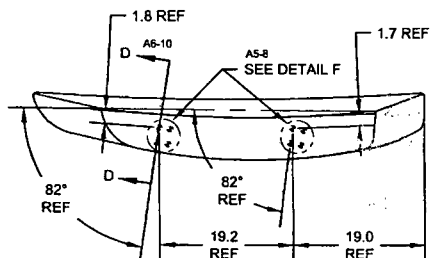
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:

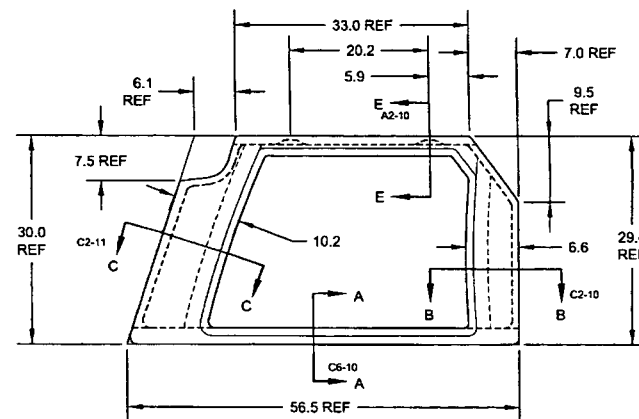
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2009-10-20

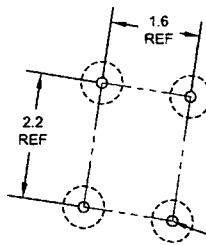
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY







DETAIL F

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

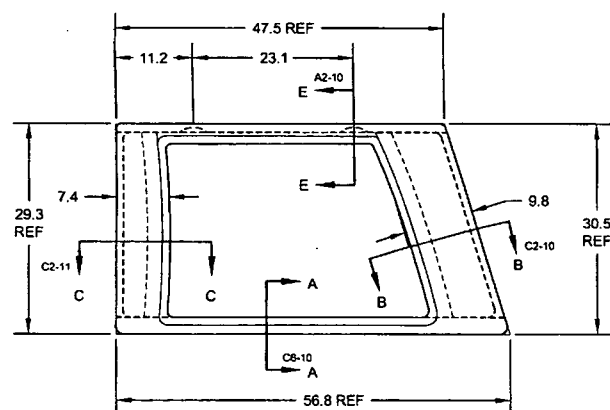
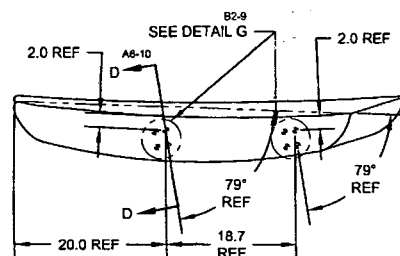
D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

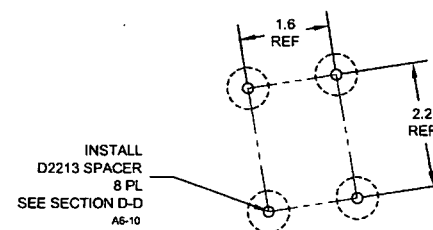
RELEASED
2009-10-23

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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D3188-2M SPACEPOD BODY



DETAIL G D6-8

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2009-10-20

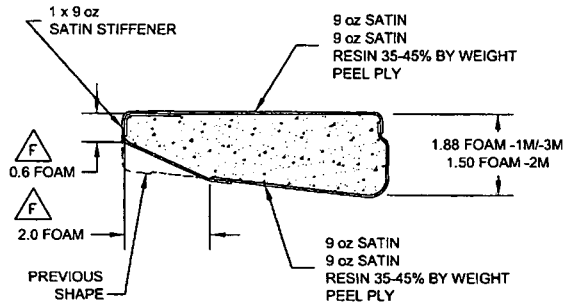
D3186-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

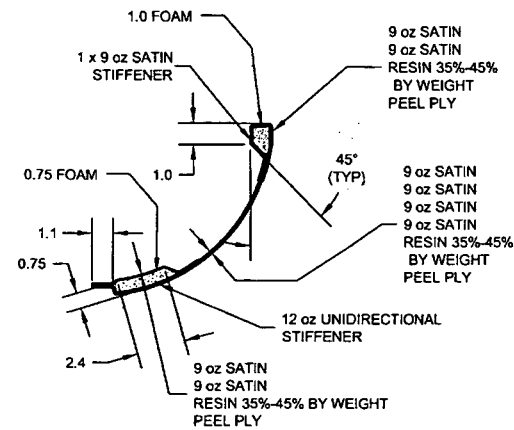
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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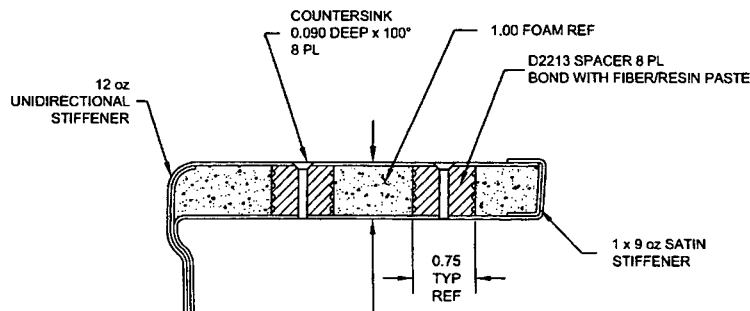
OUTBOARD



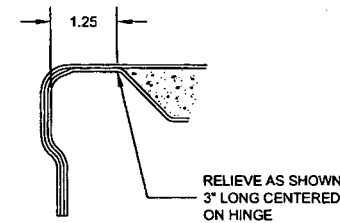
SECTION A-A
TYPICAL FLOOR SECTION
B7-8
B3-8
B6-8



SECTION B-B
SECTION C-C OPPOSITE
B6-8
B8-8
B4-8
B2-8
B7-8
B5-8



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS
D3-8
D7-8
D6-8



SECTION E-E
2 PLACES PER POD
C2-8
C7-8
B6-8

RELEASED
2009-10-27

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 10 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
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OUTBOARD

INSTALL AKS7-1032-130
INSERTS 29 PL
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
REF

PREVIOUS
SHAPE



SECTION H-H
TYPICAL FLOOR SECTION

A5-2
A5-3
A5-4
A5-5
B5-6
B5-7

SPACEPOD INNER SKIN

SPACEPOD OUTER SKIN

Ø0.172

Ø0.37

HYSOL 934NA W/
MILLED GLASS FIBRES
OR METALSET A4

FOAM
REF

0.25

SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-5
C4-6
C5-7

RELEASED
2009-10-20

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 11 OF 11
APPROVED	RF	TITLE	SCALE
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5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
29**	29**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D130-780

Page 33 of 34

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D130-780

Page 34 of 34

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY
REF. EASA.IM.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door Hinge Kit.

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-13	DOOR PROP

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.

Weight and Balance change associated with this DSI is negligible.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.02.03
CERT. NO.:	SH93-88
ISSUE NO.:	6

A	NEW ISSUE	<i>[Signature]</i>	10.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. REV. A	
CHECKED	<i>[Signature]</i>	DSI 9502 SHEET 1 OF 1	
MFG. APPR.	N/A	SCALE	
APPROVED	<i>[Signature]</i>	TITLE	
DE APPR.	<i>[Signature]</i>	REPLACEMENT DOOR PROP NTS	
DATE	10.02.03	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries